

LISTING OF CLAIMS

Claim 1 (cancelled)

Claim 2 (three times amended)

Claims 3 through 8 (previously amended)

Claims 9 and 10 (original)

Claim 11 (previously amended)

Claim 12 (original)

Claims 13 and 14 (previously amended)

Claims 15 through 17 (original)

Claims 18 through 20 (cancelled)

CLAIM AMENDMENT

Please amend Claim 2 as follows:

2. (Three Times Amended) ~~A method according to Claim 1 including~~ In a method of fabricating a metal security door having a frame formed with a pair of hollow, upright stile members, upper and lower transverse rail members extending between said stile members, and a plurality of transverse security bars extending between said stile members and a plurality of upright security bars extending between said rail members, and
5 further comprising the improvement comprising forming said stile members and said rail members with flat, inwardly directed attachment flanges, positioning said transverse security bars so that they pass across said attachment flanges of said stile members, and positioning said upright security bars so that they pass across said attachment flanges of
10 said rail members wherein said upright and transverse security bars reside in contact with and are spot welded to said attachment flanges across which they pass, and spot welding said security bars to said stile and rail members by spot welding them to said attachment flanges across which they pass.